

Date: Tuesday, 12/5/2006 9:07:02 AM
 User: Jim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : X-TUBE AS 350/355 HI FWD
 Job Number : 29758A
 Estimate Number : 12484
 P.O. Number :
 This Issue : 12/5/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D350748141
 First Issue : / / Type : LANDING GEAR Drawing Number : D350-748-141
 Previous Run : 29757A Project Number : N/A
 Drawing Revision : C UNDER REVIEW D
 Material :
 Due Date : 1/30/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *AG 061205*
 Comment : Est Rev: A New Issue 06-07-05 JLM
 Est Rev: B Update cadplate process 06-09-12 KJ

Additional Product

b Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-141 CHG001

2.0

D6017115

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Crosstube Material

D6017-115

2.339" OD X 2.000" ID

Batch: *B21471**MS 061215*

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

AG 061207 1

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

AG 061207 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:07:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD

Job Number: 29758A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA648

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

3-Scribe Part & Batch as per Dwg D350-748-141

TSC 06.12.07

1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BC 06.12.07

1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.12.07

1

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Remove all Maching Marks

Pm/JP

06/12/13

①

9.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 2725

C 206/12/15

①

Heat Treat to min 180 KSI As per Dwg D350-748-141

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformaty is attached

P 7/1/12

H:\FORMS\Quality Assurance\process

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:07:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD

Job Number: 29758A

Part Number: D350748141

Job Number:



Seq: #:

Machine Or Operation:

Description:

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11/07/01/29

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

11/07-1-30

13.0

QC5

INSPECT WORK TO CURRENT STEP

QUS



Comment: INSPECT WORK TO CURRENT STEP

11/07-01 @

PTO

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

11/07-02-20

2-Debur

11/07-02-20

3-Engrave Part # and Batch # as per Dwg D350-748-141

4-Remove all marks from tube within limits of D350-748-141

5- Apply a light coat of LPS3 on the interior of tube

Batch: 11/07-03-45

11/07-2-26

PTO

15.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11/07-26 @

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 3206

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per QQ-P-416F, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

11/07/02/28
①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-02-01	130	QCS req'd. Perm. Change <i>[Signature]</i>				<i>[Signature]</i> 07-02-01	<i>[Signature]</i> 07-02-01	
07-02-01	140	QCS needed after 14.0. perm. Change <i>[Signature]</i>				<i>[Signature]</i> 07-02-01	<i>[Signature]</i> 07-02-01	
		QCS inspect work to current step.	<i>[Signature]</i>	07-02-26	①	<i>[Signature]</i> 07-02-01	<i>[Signature]</i> 07-02-01	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:07:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD

Job Number: 29758A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

12/4/13 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(PTO)

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Prime Outside of Tube as per Dart QSI 005 4.2

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

21.0

D35021

SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SUPPORT

Batch: _____

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: _____

23.0

ALS41032225

Insert



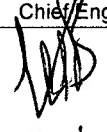
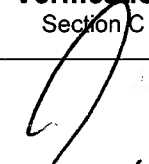
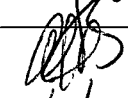
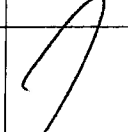
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-141 PAR #: N/A Fault Category: Prod / ~~Prod~~ ^{x-tube} NCR: Yes No DQA: D Date: 08/04/04
 QA: N/C Closed: _____ Date: _____

NCR: 29758A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-19	16-0	x-tube was found to have indication of cracks during metal particle inspection.	 08/03/31	Scrap: destroy tube. - cut cuffs up 16" from the end, for HAZ	SR 8-1-3	 2008-31	 08/03/31	 07-12-19

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:07:43 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD

Job Number: 29758A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: _____

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: _____

26.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: _____

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-241

Location: _____

PPP Rev: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:07:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD

Job Number: 29758A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-03-31

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29758A
Description: Crosstube Assembly (AS350/355 High Fwd)		Part Number:	D350-748-141
Inspection Dwg: D350-748-141 Rev: <i>8 D 06.12.07</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

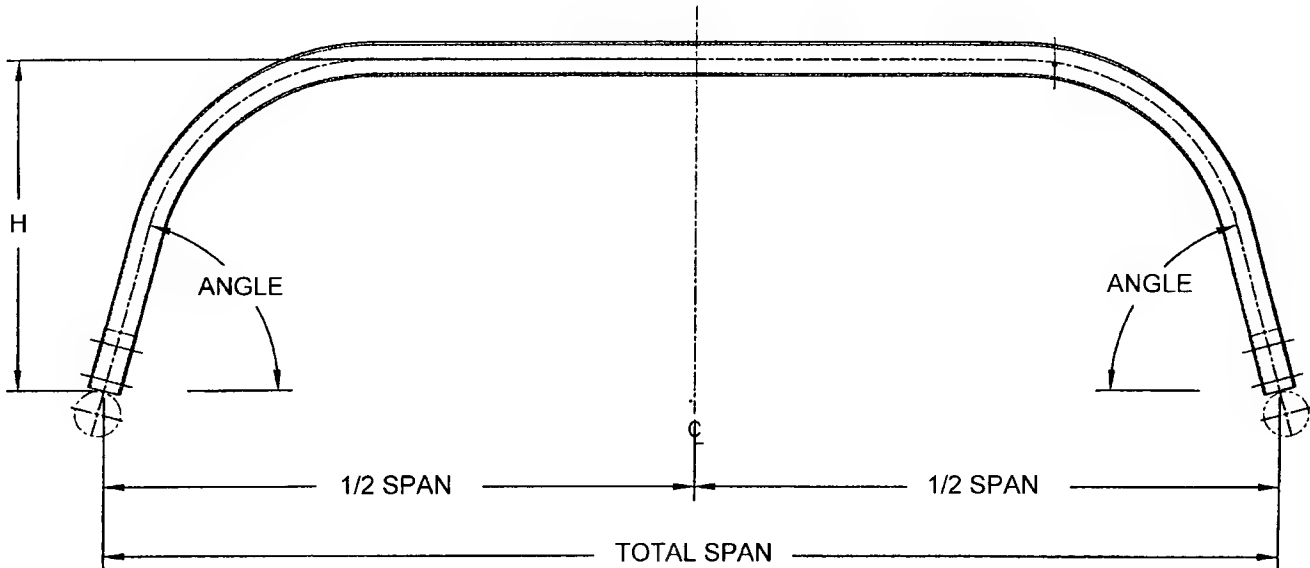
☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244	—			
	2.180	+0.005/-0.000	2.185				
	2.180	+0.005/-0.000	2.185				
	2.237	+0.005/-0.000	2.242				
	2.272	+0.005/-0.000	2.277				
	2.306	+0.005/-0.000	2.311				
	2.339	+0.005/-0.000	2.344				
	2.339	+0.005/-0.000	2.342				
	0.062	+/-0.010	0.062				
	4.26	+/-0.030	4.26				
	R0.063	+/-0.010	0.063				
	R0.50	+/-0.030	0.500				
SIDE B	2.240	+0.005/-0.000	2.244				
	2.180	+0.005/-0.000	2.185				
	2.180	+0.005/-0.000	2.185				
	2.237	+0.005/-0.000	2.242				
	2.272	+0.005/-0.000	2.277				
	2.306	+0.005/-0.000	2.311				
	2.339	+0.005/-0.000	2.342				
	2.339	+0.005/-0.000	2.342				
	0.062	+/-0.010	0.062				
	4.26	+/-0.030	4.26				
	R0.063	+/-0.010	0.063				
	R0.50	+/-0.030	0.500				
	110.27	+/-0.060	110.27				

Measured by:	<i>SC</i>	Audited by:	<i>SA</i>	Prototype Approval:	N/A
Date:	<i>06.12.07</i>	Date:	<i>06.12.07</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM <i>JA</i>	<i>BE</i>

Crosstube Bend Dimension Sheet



PART NUMBER: _____

BATCH NUMBER: 29758A

DRAWING: _____ REVISION: _____

H: _____

1/2 SPAN: _____

TOTAL SPAN: _____

ANGLE: _____

QC 15: _____

DATE: _____

QTY: _____

DART**RELEASED**

06.10.31

DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

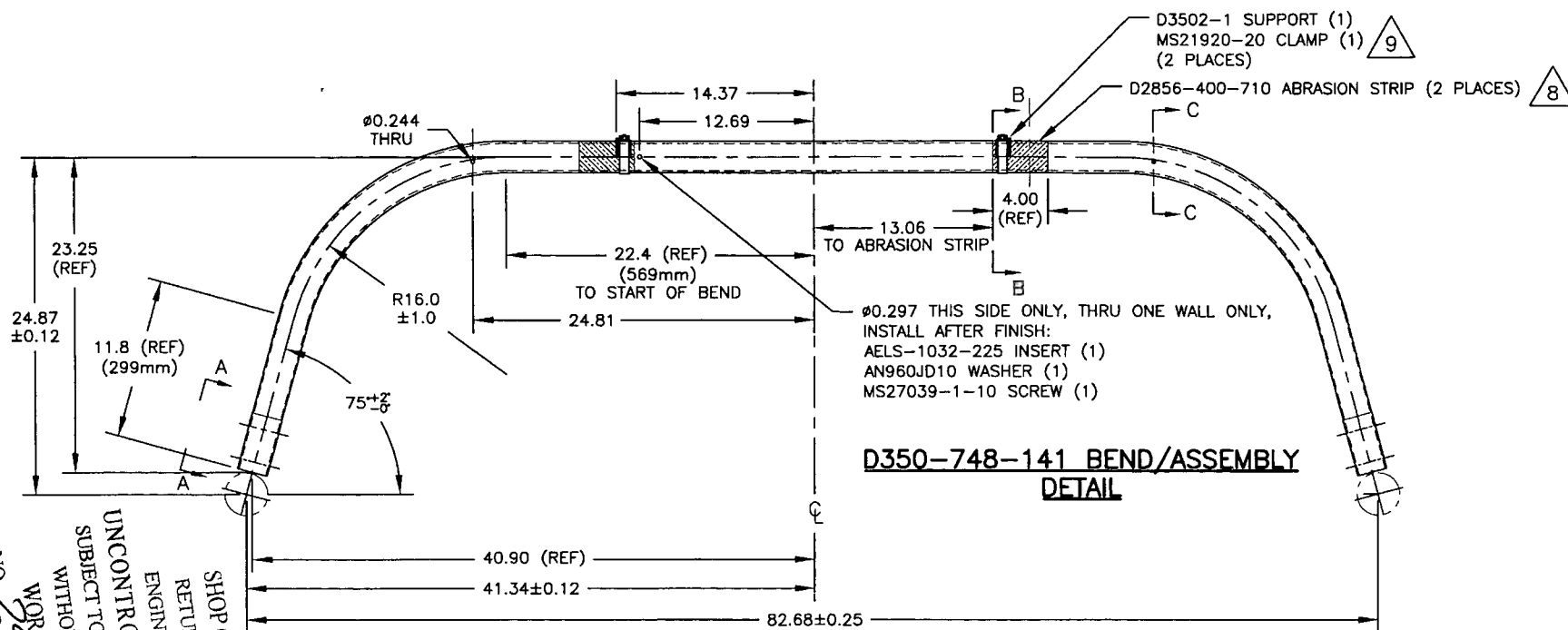
D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27 ± 0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR $\varnothing 0.297$ HOLE.

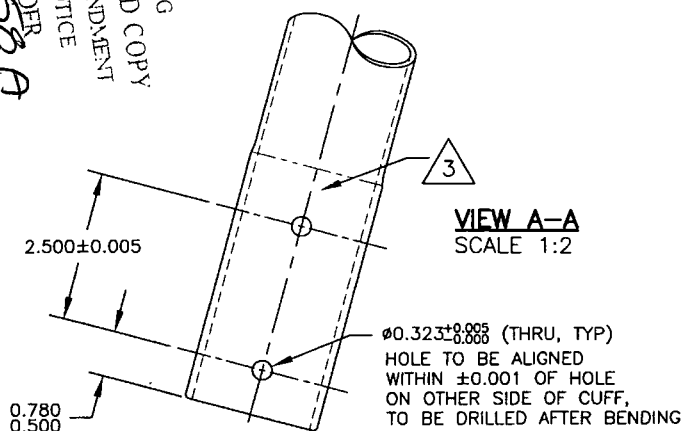
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NOTED TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29758A

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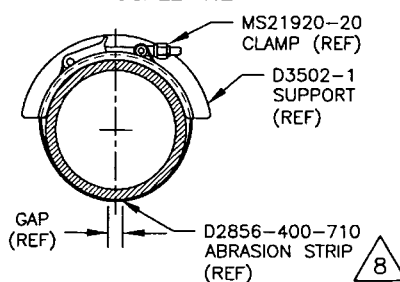
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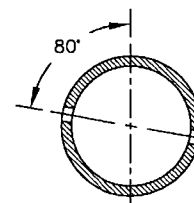
NO. 29758 A
 WORK ORDER
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 SHOP COPY
 RETURN TO
 ENGINEERING



SECTION B-B
 SCALE 1:2



SECTION C-C
 SCALE 1:2



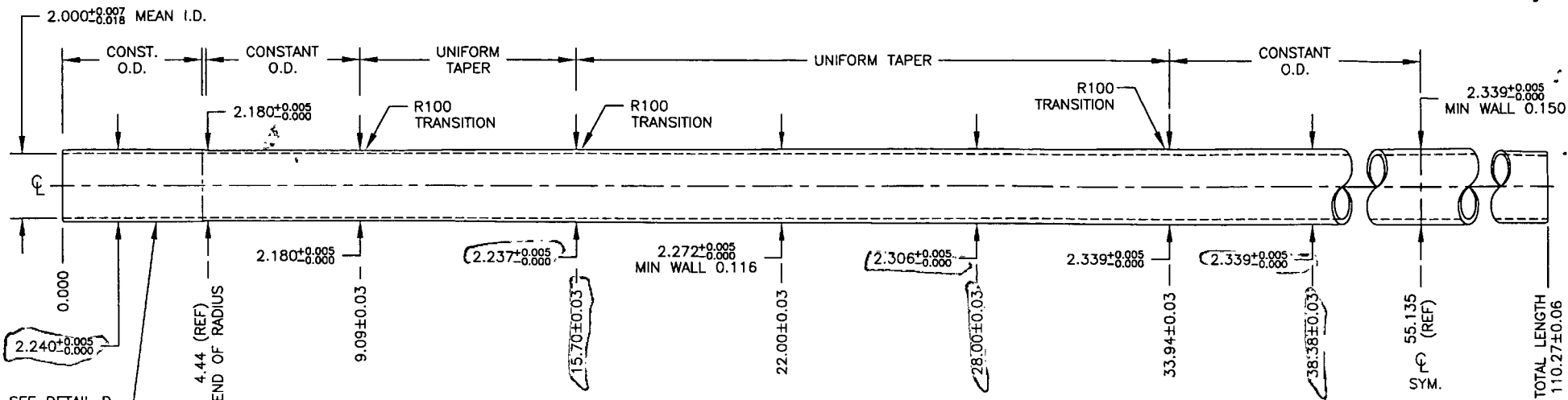
RELEASED

06.10.31

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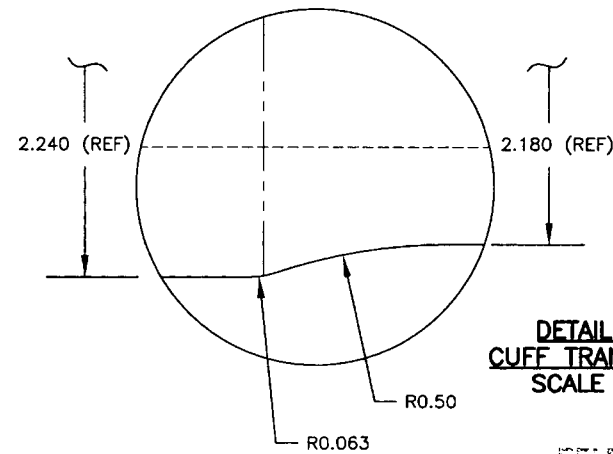
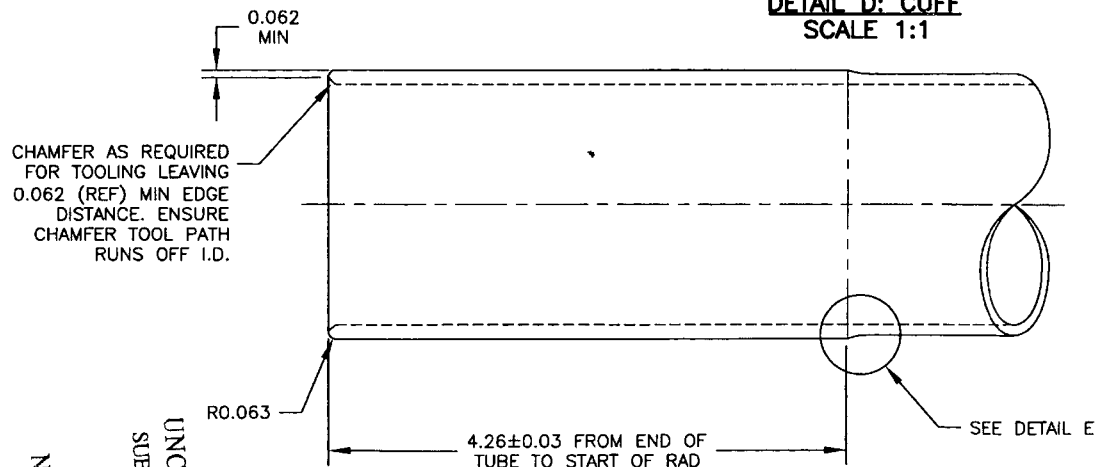
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DESIGN	90	DRAWN BY	90	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
				D350-748-141	SHEET 2 OF 3
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI FWD)	SCALE	1:8



D350-748-141 MACHINING DETAIL

**DETAIL D: CUFF
SCALE 1:1**



**DETAIL E:
CUFF TRANSITION
SCALE 9:1**

RELEASED

06.10.31

NO. 297588A
WORK ORDER
SUBJECT TO AMENDMENT
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RETURN TO
SHOP COPY
RETURN TO

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DESIGN qp	DRAWN BY qp	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D350-748-141	REV. 0 SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE 1:3	



VAC AERO
INTERNATIONAL INC.

RELEASE NO

GST No. : R105468102

OAK 82647-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VERITE STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

01/11/2007

MM/DD/YYYY

PAGE : 1

BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
01/11/2007	EPIC EXPRESS	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00002725		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-CROSS TUBES D350-748-141-241		EA	8	8	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180-200 KSI PER AMS 2759-1C 100% HARDNESS TESTED PER ASTM E-18 HRC 40-43 MATERIAL: 4130</p> <p>REF. PS# 59054 RE: B29758A, B29757A, B29760A, B29765A, B29761A, B29764A, B29763A, B29762A</p>					

100% HARDNESS TESTED
8 pcs.

42/43 HRC



11/01/29

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC

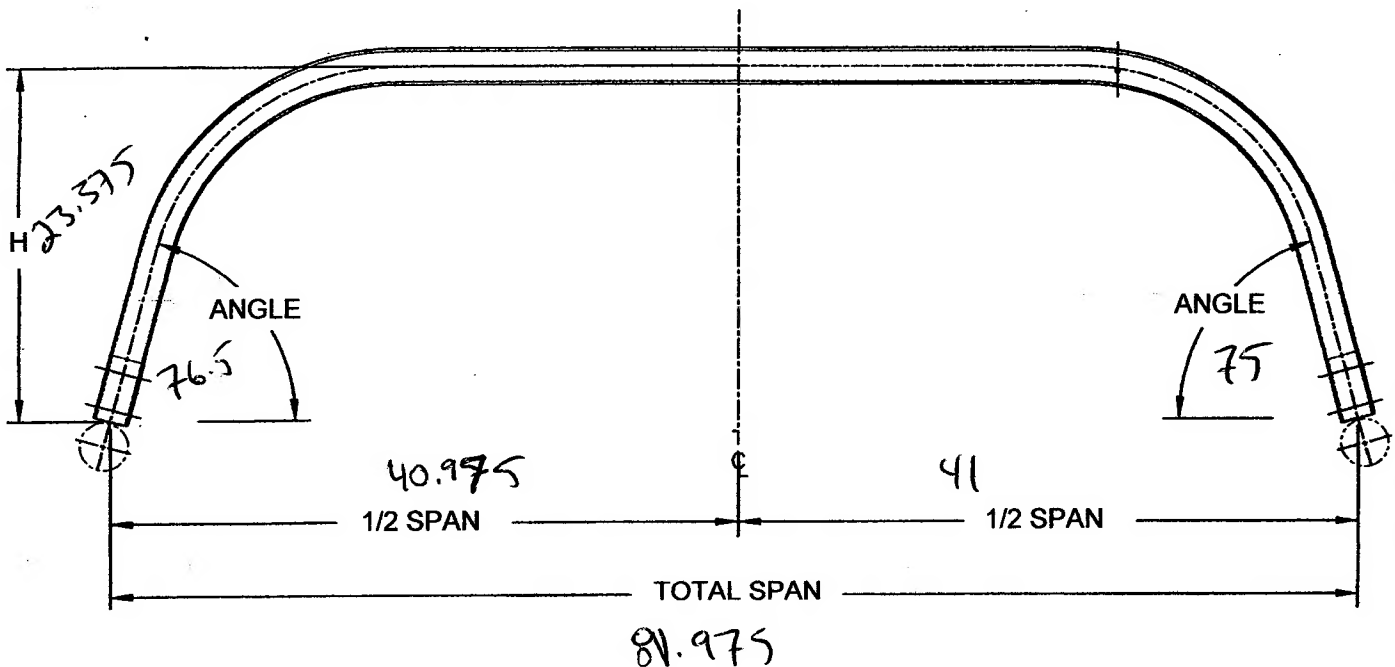
Sandra Sherman
Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS



Crosstube Bend Dimension Sheet



PART NUMBER: 1350-748-141

BATCH NUMBER: 2975B

DRAWING: -141 REVISION: C

H: 23.25

1/2 SPAN: 40.5

TOTAL SPAN: 81.8

ANGLE: 75 \pm 2
-0

QC 15: [Signature]

DATE: 070201

QTY: 1



Southwest United Industries, Inc.

SOUTHWEST UNITED INDUSTRIES, INC.
422 S. St. Louis Tulsa, OK 74120

Page 1 of 1

CERTIFICATION

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Certification #: 24369

Certification Date: 03/29/2007

Qty	Part Number/Description	Job-No/Order-No/Ctl-No
1	D350-748-141 CROSSTUBE	48089 PO00003206 B29758

1. Stress relieve at 350-400F for 4 hours minimum
2. Cadmium plate per AMS-QQ-P-416B, Type II, Class 1 (QQ-P-416, Type II, Class 1)
3. Embrittlement relieve within 4 hours of plating at 350-400F for 8 hours minimum
4. Magnetic particle inspect per ASTM E 1444-05. No linear indications/cracks allowed.

Qty Ins: 1 Qty Rej: 1 Qty Acc: 0

Reference attached NCR 48089-N01

We certify that the parts listed above have been processed in accordance with the requirements and specifications of the above referenced purchase order. Documentation is on file and available for review.

Certification By:

SMITH, JUSTIN



FAA Repair Station CN2R748K

Subject to Southwest United Industries, Inc. Standard Terms and Conditions available for review at www.swunited.com

